

Date: Wednesday, 1/11/2006 4:30:52 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SPRING CLIP ASSEMBLY
Job Number : 25484	
Estimate Number : 10645	
P.O. Number : N/A	Part Number : D2429041
This Issue : 1/11/2006 S.O. No. : N/A	Drawing Number : D2429 REV C1
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : PURCHASED PARTS	Drawing Revision : C1
Previous Run : N/A	Material : N/A
Written By : SEE COMMENT BELOW	Due Date : 1/31/2006
Checked & Approved By : SEE COMMENT BELOW	Qty: 40 u
Comment : Est. D 02.03.06 Added note at step 7 NG	Um: 12 Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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**Comment:** PURCHASING

Note: Qty 2 pieces required per assembly

Issue P/O 377

Make D2429-1 Flat Pattern as per Dwg D2429

Material release note required

u 06-01-12 40

2.0	D24291F	Spring Clip Ass'y
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)
 Spring Clip Ass'y

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage

Ensure Material Release Note is attached

C 06/02/06 40

4.0	QC5	INSPECT WORK TO CURRENT STEP
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**Comment:** INSPECT WORK TO CURRENT STEP

06-02-06

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1

1-Deburr

2-Bend D2429-1 as per Dwg D2429

DL 06/02/06 50
SB 06/02/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/11/2006 4:30:52 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPRING CLIP ASSEMBLY

Job Number: 25484

Part Number: D2429041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

MS20470AD45

Rivet, Universal Head



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

Rivet, Universal Head

Pick:

Qty	Part number	Description	Batch
1	MS20470AD4-5	Rivet	M17243

7.0

AN960JD6L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 24.0000 Each(s)

Washer

Pick:

Qty	Part number	Description	Batch
2	AN960JD6L	Washer	M5519

NOTE: 2 D2429-1 required for 1 assy.

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: Assemble D2429-041 as per Dwg D2429

SB 06/02/14 25

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-02-14 25

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 544

06/02/14 25

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21 SUE 06/02/15 25

06/02/15 25

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: DD Date: 06/02/15
 QA: N/C Closed: _____ Date: _____

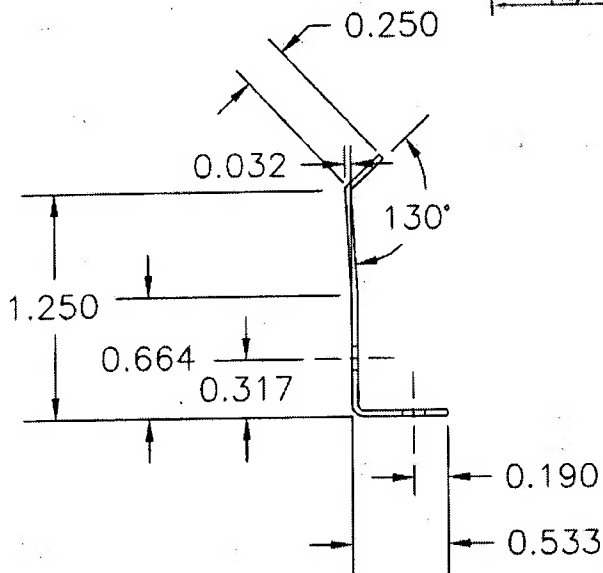
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

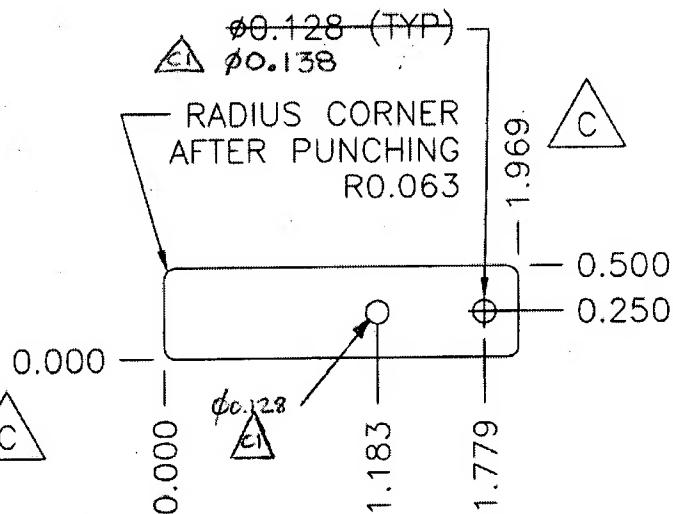


DESIGN KE	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2429	REV. C SHEET 1 OF 1
DATE 00.06.26		TITLE SPRING CLIP	SCALE 1:1
A	95.07.21	NEW ISSUE	
B	97.10.09	ADDED ASSEMBLY	
C	00.06.26	1.969 WAS 2.100; 0190 WAS 0.321	
C1	01.03.27	Ø0.138 WAS Ø0.128	

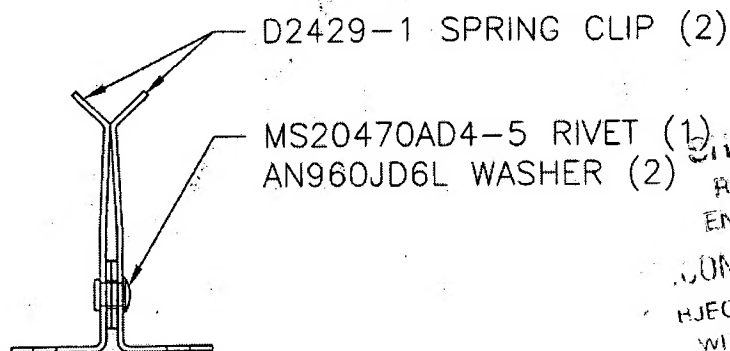
RELEASED
00-06-27 [Signature]



D2429-1 SPRING CLIP



D2429-1 FLAT PATTERN



D2429-041 SPRING CLIP ASSEMBLY

MATERIAL: AISI 304/316 SS 0.040 THICK 0.50 WIDE
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSION ARE IN INCHES

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25484

PART NO.